

Work Order ID 78918 -1

January-17-12 9:00:53 AM

78918

Page 1

Item ID: D3197-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar Assembly

Start Date: 17/01/2012 Start Qty: 6.00 *2* *6*

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 6.00 *6*

Customer:

Reference:

Approvals: Process Plan: *M C G*

Date: *12/01/12* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D3197 Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

AO 12/01/12
BA 12/01/12

6 4

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to length per dwg D31972-Machine D3197-1 as per Folio FA340 and Dwg D31973-Deburr

12/01/12 *value = 6*

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

12/01/12 *value = 6*

6

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar Assembly

Start Date: 17/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

0.00

130

CONVENTIONAL LATHE

Lathe Conv

Memo

0.00

Conventional Lathe

Chamfer as per Dwg D3197

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

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Revision ID:

Item Name: Bar Assembly

Stop *NS2*

Start Date: 17/01/2012 Start Qty: 6.00

6

Required Date: 31/01/2012 Req'd Qty: 6.00

6

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE

FINISH TIME:

1:40

M118484

32001-

6XPM-L 12/02/06

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

6 BL 12-2-6

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

Assemble D3197-041 as per Dwg D3197

GP 12/02/06 (2)

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Item ID: D3197-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar Assembly

Start Date: 17/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 260

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/2/06
12/2/07
12-02-06

Picklist Print

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Work Order ID: 78918

78918

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar Assembly

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24 *MS27039-1-24* Screw		Purchased	No			100	Each	70.0000	2	12			

Location

ST292

Loc Qty

70

Loc Code

100151

70

AN960ID10
AN960ID10
Washer

NAS1149D0363J

Purchased

No

4 M119537 (12x)

180

Each

0.0000

6

36

**

D2690-5

Manufactured

No

D2690-5

Lanyard Assembly

180

Each

5.0000

2

12

**

Location

ST013

Loc Qty

5

Loc Code

73321

5

D3242-1

Manufactured

No

D3242-1

Tag

180

Each

8.0000

2

12

**

Location

ST034

Loc Qty

8

Loc Code

76162

8

Picklist Print

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Work Order ID: 78918

Parent Item: D3197-041

Parent Item Name: Bar Assembly

78918

D3197-041

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 6.00

Required Qty: 6.00

D3489-3-200

Manufactured

No

180

Each

8.0000

2

12

**

D3489-3-200

PIP PIN

Location

Loc Qty

Loc Code

GA

8

75792

8

M7075T73R1.000

Purchased

No

180

1

25.5150

2.42

18.15

**

M7075T73R1 000

7075-T73 Rd Bar 1.00

Location

Loc Qty

Loc Code

MAT012

25.515

115165

2.7

116405

4.54

116604

2.25

116835

2.32

116962

0.905

118305

12

119049

0.8

MS21042L3

Purchased

No

180

Each

5.787.000

2

12

**

MS21042L 3

Nut

Location

Loc Qty

Loc Code

ST300

5787

117441

16

117885

32

118451

5

118927

3

119017

5259

119075

472

January-17-12 9:00:57 AM

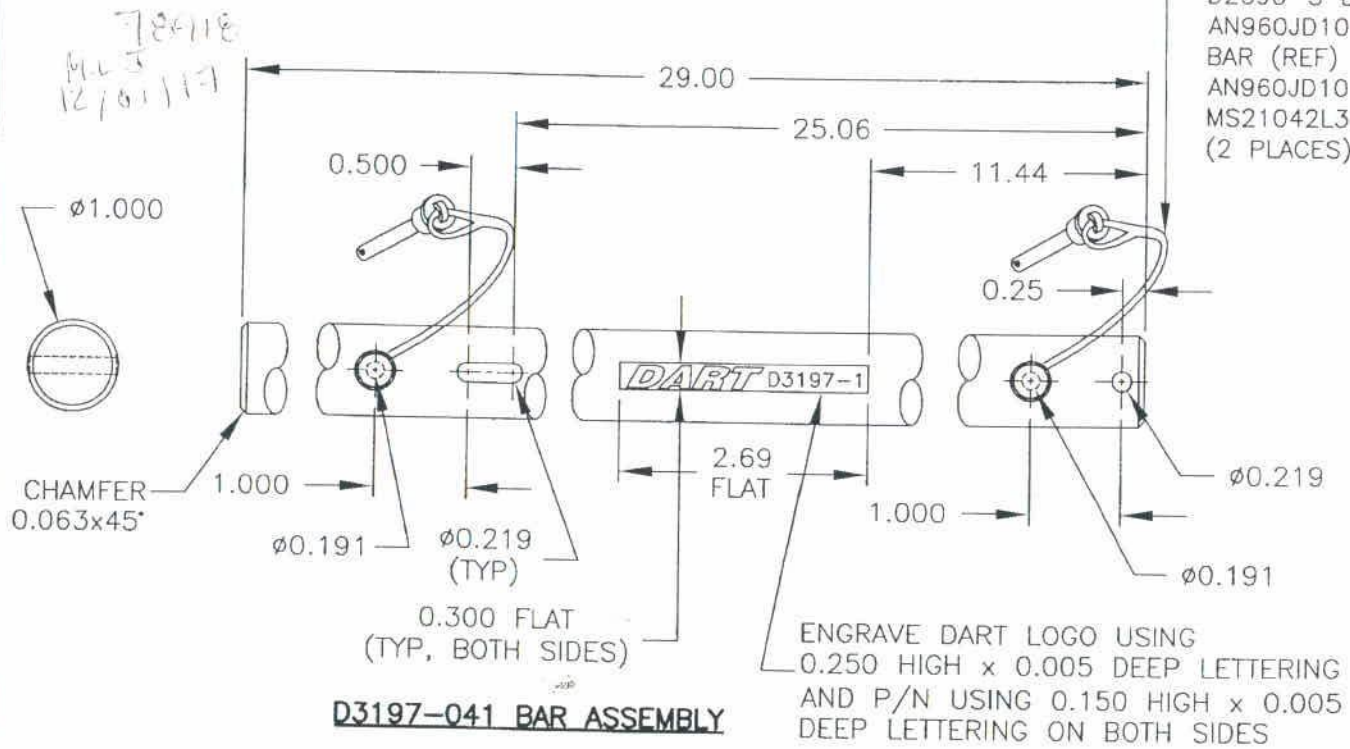
Shop Packet Print

Page 2

RELEASED

DART

- D3489-3-200 PIP PIN (1)
- D3242-1 TAG (1)
- MS27039-1-24 BOLT (1)
- AN960JD10 WASHER (1)
- D2690-5 LANYARD (1)
- AN960JD10 WASHER (1)
- BAR (REF)
- AN960JD10 WASHER (1)
- MS21042L3 NUT (1)
- (2 PLACES)



D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D. (REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	DATE	03.07.01	DRAWING NO. D3197
		TITLE	BAR	REV. B
				SHEET 1 OF 1
				SCALE 1:1
				CHG PIP PIN; ADD D3242-1 TAG

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1. General Information 2. Vehicle Information 3. Inspection Details 4. Inspection Results 5. Inspector's Signature 6. Vehicle Owner's Signature 7. Notes 8. Additional Information 9. Inspector's Contact Information 10. Vehicle Owner's Contact Information 11. Inspector's License Number 12. Vehicle Owner's License Number 13. Inspector's Date of Birth 14. Vehicle Owner's Date of Birth 15. Inspector's Address 16. Vehicle Owner's Address 17. Inspector's Phone Number 18. Vehicle Owner's Phone Number 19. Inspector's Email Address 20. Vehicle Owner's Email Address 21. Inspector's Social Security Number 22. Vehicle Owner's Social Security Number 23. Inspector's State of Residence 24. Vehicle Owner's State of Residence 25. Inspector's Date of Inspection 26. Vehicle Owner's Date of Inspection 27. Inspector's Signature (Print Name) 28. Vehicle Owner's Signature (Print Name) 29. Inspector's Signature (Signature) 30. Vehicle Owner's Signature (Signature) 31. Inspector's Signature (Signature) 32. Vehicle Owner's Signature (Signature) 33. Inspector's Signature (Signature) 34. Vehicle Owner's Signature (Signature) 35. Inspector's Signature (Signature) 36. Vehicle Owner's Signature (Signature) 37. Inspector's Signature (Signature) 38. Vehicle Owner's Signature (Signature) 39. Inspector's Signature (Signature) 40. Vehicle Owner's Signature (Signature) 41. Inspector's Signature (Signature) 42. Vehicle Owner's Signature (Signature) 43. Inspector's Signature (Signature) 44. Vehicle Owner's Signature (Signature) 45. Inspector's Signature (Signature) 46. Vehicle Owner's Signature (Signature) 47. Inspector's Signature (Signature) 48. Vehicle Owner's Signature (Signature) 49. Inspector's Signature (Signature) 50. Vehicle Owner's Signature (Signature) 51. Inspector's Signature (Signature) 52. Vehicle Owner's Signature (Signature) 53. Inspector's Signature (Signature) 54. Vehicle Owner's Signature (Signature) 55. Inspector's Signature (Signature) 56. Vehicle Owner's Signature (Signature) 57. Inspector's Signature (Signature) 58. Vehicle Owner's Signature (Signature) 59. Inspector's Signature (Signature) 60. Vehicle Owner's Signature (Signature) 61. Inspector's Signature (Signature) 62. Vehicle Owner's Signature (Signature) 63. Inspector's Signature (Signature) 64. Vehicle Owner's Signature (Signature) 65. Inspector's Signature (Signature) 66. Vehicle Owner's Signature (Signature) 67. Inspector's Signature (Signature) 68. Vehicle Owner's Signature (Signature) 69. Inspector's Signature (Signature) 70. Vehicle Owner's Signature (Signature) 71. Inspector's Signature (Signature) 72. Vehicle Owner's Signature (Signature) 73. Inspector's Signature (Signature) 74. Vehicle Owner's Signature (Signature) 75. Inspector's Signature (Signature) 76. Vehicle Owner's Signature (Signature) 77. Inspector's Signature (Signature) 78. Vehicle Owner's Signature (Signature) 79. Inspector's Signature (Signature) 80. Vehicle Owner's Signature (Signature) 81. Inspector's Signature (Signature) 82. Vehicle Owner's Signature (Signature) 83. Inspector's Signature (Signature) 84. Vehicle Owner's Signature (Signature) 85. Inspector's Signature (Signature) 86. Vehicle Owner's Signature (Signature) 87. Inspector's Signature (Signature) 88. Vehicle Owner's Signature (Signature) 89. Inspector's Signature (Signature) 90. Vehicle Owner's Signature (Signature) 91. Inspector's Signature (Signature) 92. Vehicle Owner's Signature (Signature) 93. Inspector's Signature (Signature) 94. Vehicle Owner's Signature (Signature) 95. Inspector's Signature (Signature) 96. Vehicle Owner's Signature (Signature) 97. Inspector's Signature (Signature) 98. Vehicle Owner's Signature (Signature) 99. Inspector's Signature (Signature) 100. Vehicle Owner's Signature (Signature)

Work Order:	Part Number:	Inspection Dwg: 03.192 Rev: 11
DESCRIPTION: 45-1	Part Number: 45-1	Page 1 of 1